

Friday, 8/3/2007 6:22:31 AM  
Jean-Luc Menard

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STEP LEG
Job Number	33819		
Estimate Number	10382		
P.O. Number	N/A	Part Number	D30655
This Issue	8/3/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3065 REV.B
First Issue	N/A	Project Number	N/A
Previous Run	33510C	Drawing Revision	B
Written By	<i>JL/M 07-08-07</i>	Material	N/A
Checked & Approved By		Due Date	8/15/2007
Comment	Qty: 50 Um: Each		
Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM Est Rev:E Now manufactured with 6061-T6 06-05-25 JLM			

## Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6S080	6061-T6 .080 Sheet 	
Comment: Qty.: 1.1338 sf(s)/Unit Total: 56.6895 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080) Batch: <u>M104921 (47) + 1 scrap</u> <u>M103755 (3)</u> SAP 07/08/07			
2.0	WATER JET	FLOW WATER JET 	
Comment: FLOW WATER JET 1-Cut as per Dwg D Dwg Rev: <u>B</u> Prog Rev: <u>B</u> PTO			
2-Deburr if necessary SAP 07/08/07			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAP 07/08/07			
4.0	QC8	SECOND CHECK 	
Comment: SECOND CHECK <u>En 07/08/08</u>  XSC			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  MF 07-08-28 50	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack <i>open holes and sets to correct clin.</i> AVN 07/08/09			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-5 PAR #: N/A Fault Category: Prod / Far. ass<sup>med & small</sup> NCR: Yes No DQA: D Date: 07/08/28  
 QA: N/C Closed:  Date: 07.08.28

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/07	2,0	One part scrap had to change the offset to get the hole's in balance <i>1080808</i>	<i>1080808</i>	Scrap, destroy and replace	SAD 07/08/07	<i>1080808</i>	<i>1080808</i>	<i>1080808</i>

NOTE: Date & initial all entries

Date: Friday, 8/3/2007 6:22:31 AM

User: Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 33819

Part Number: D30655

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ew 07/08/23

coated



7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 1

07-08-27

50

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 07/08/28

50

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: QA

SB 07/08/28

50

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

L 07/08/28

50

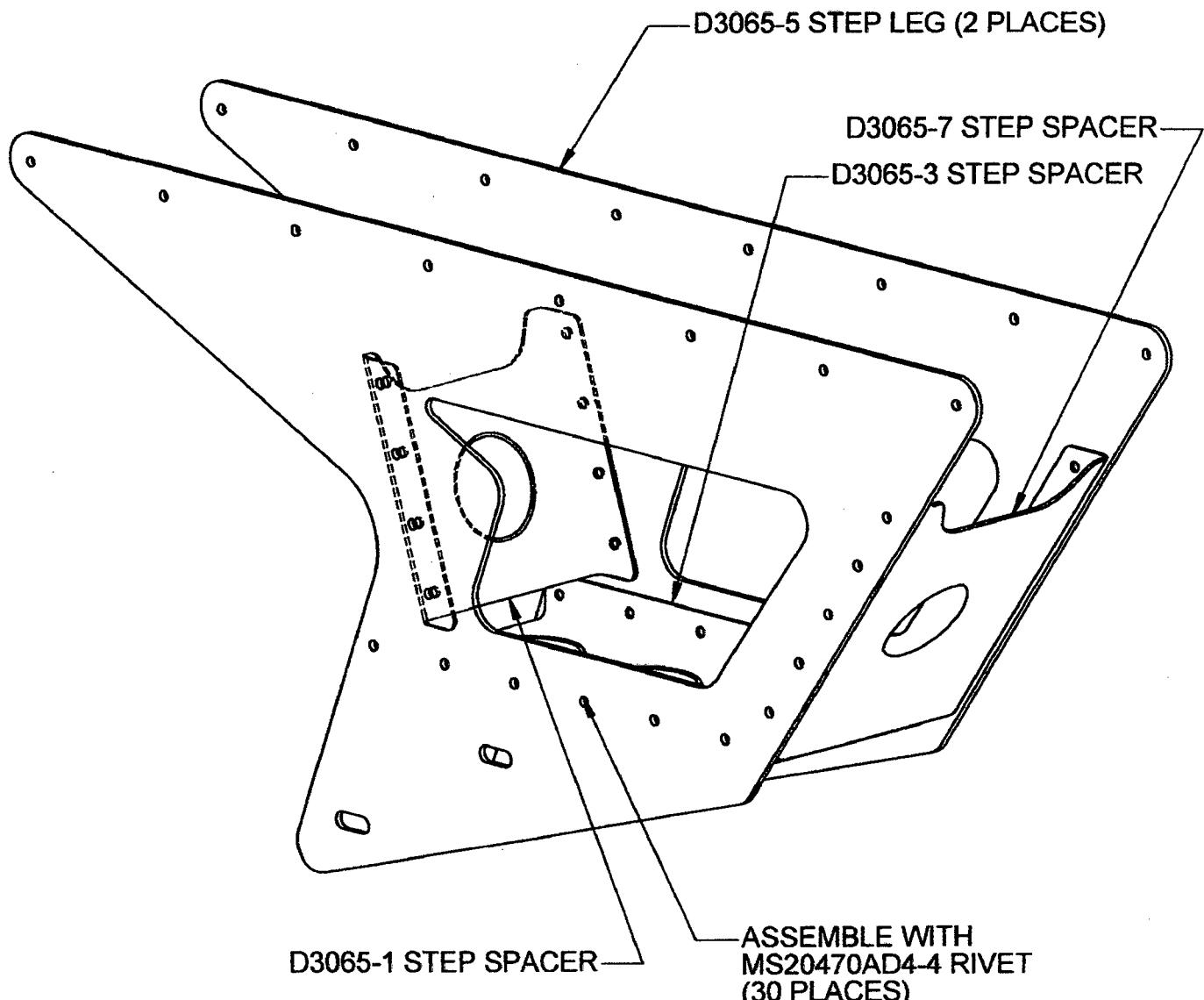
Job Completion



Co 07/08/28

**DART**

DESIGN <i>IP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 1 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2

**RELEASED***06.06.20 CFF*

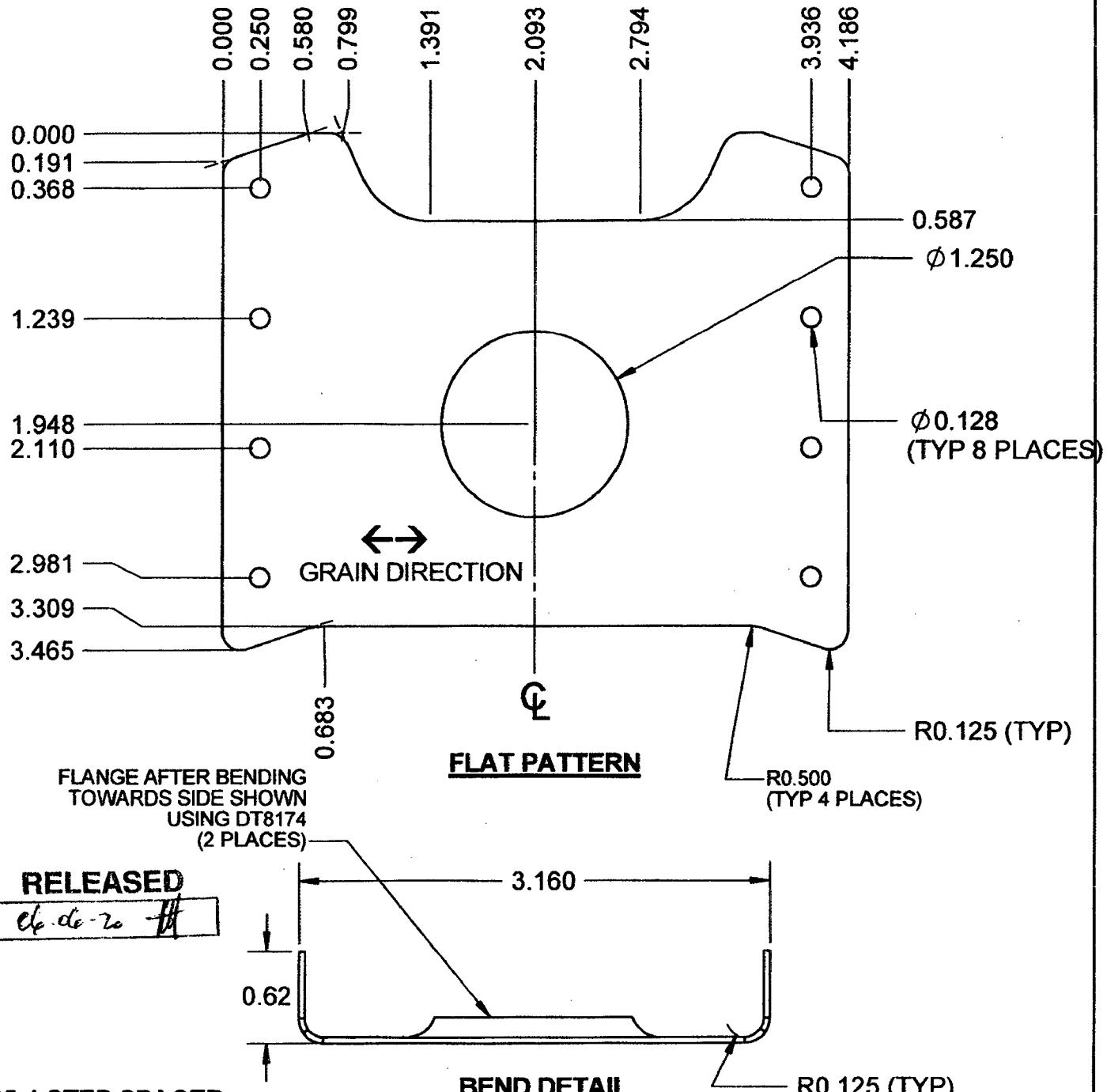
## **D3065-041 STEP LEG ASSEMBLY**

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**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	



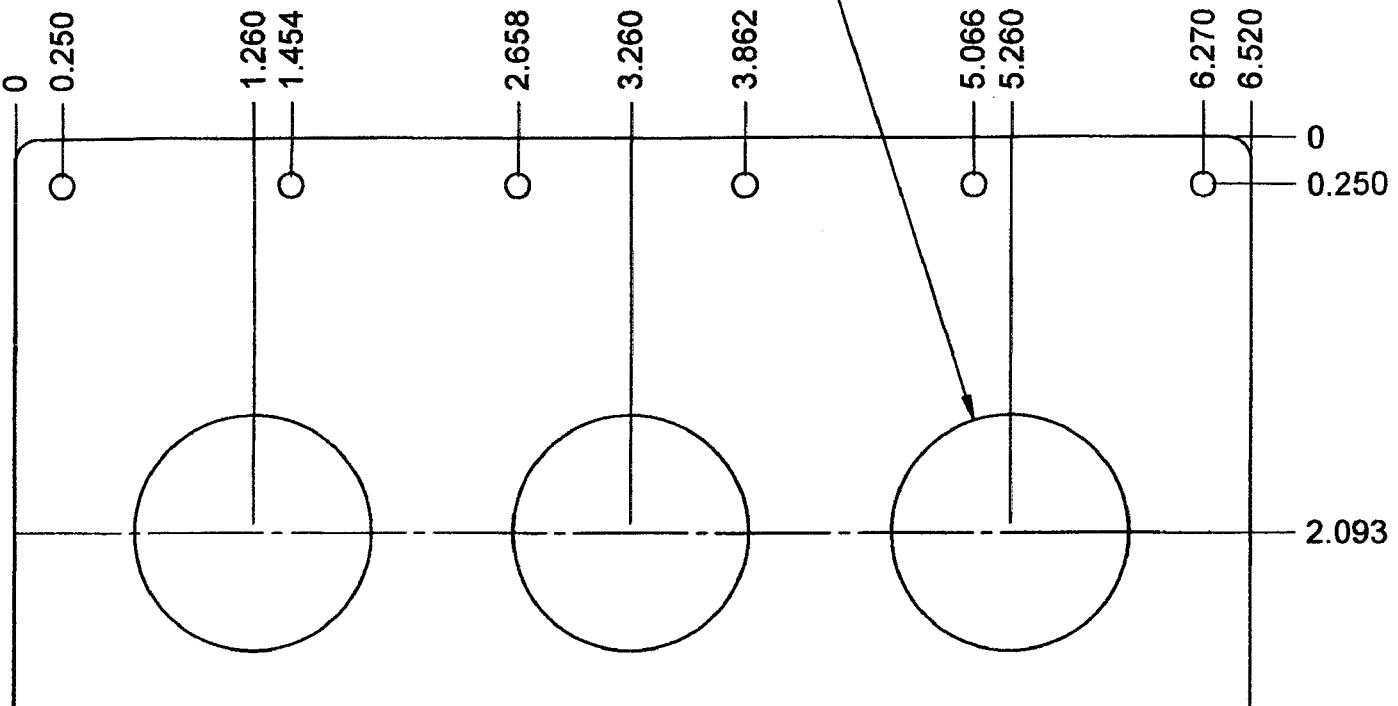
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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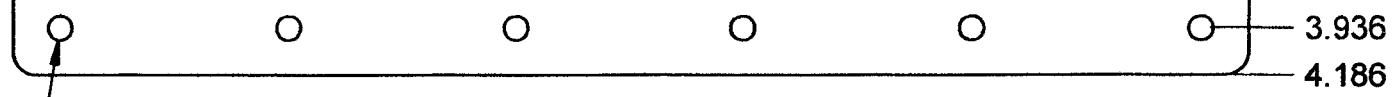
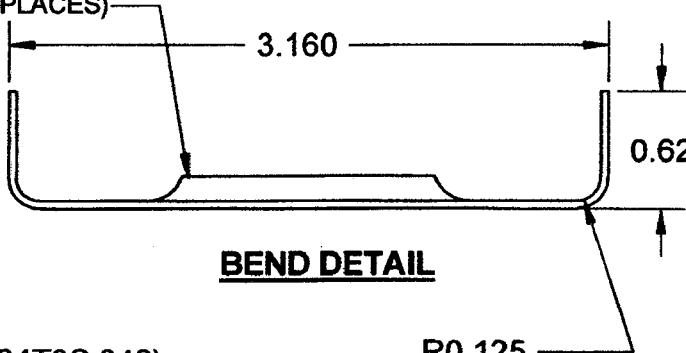
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**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. <b>D3065</b>	REV. B	SHEET 3 OF 5
DATE 06.05.23	TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1		

 $\phi 1.250$  (TYP, 3 PLACES)FLAT PATTERN

↔ GRAIN DIRECTION

FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES) $\phi 0.129$  (TYP, 12 PLACES)**RELEASED***0.6 0.6 2.0 - MM*BEND DETAIL**D3065-3 STEP SPACER**

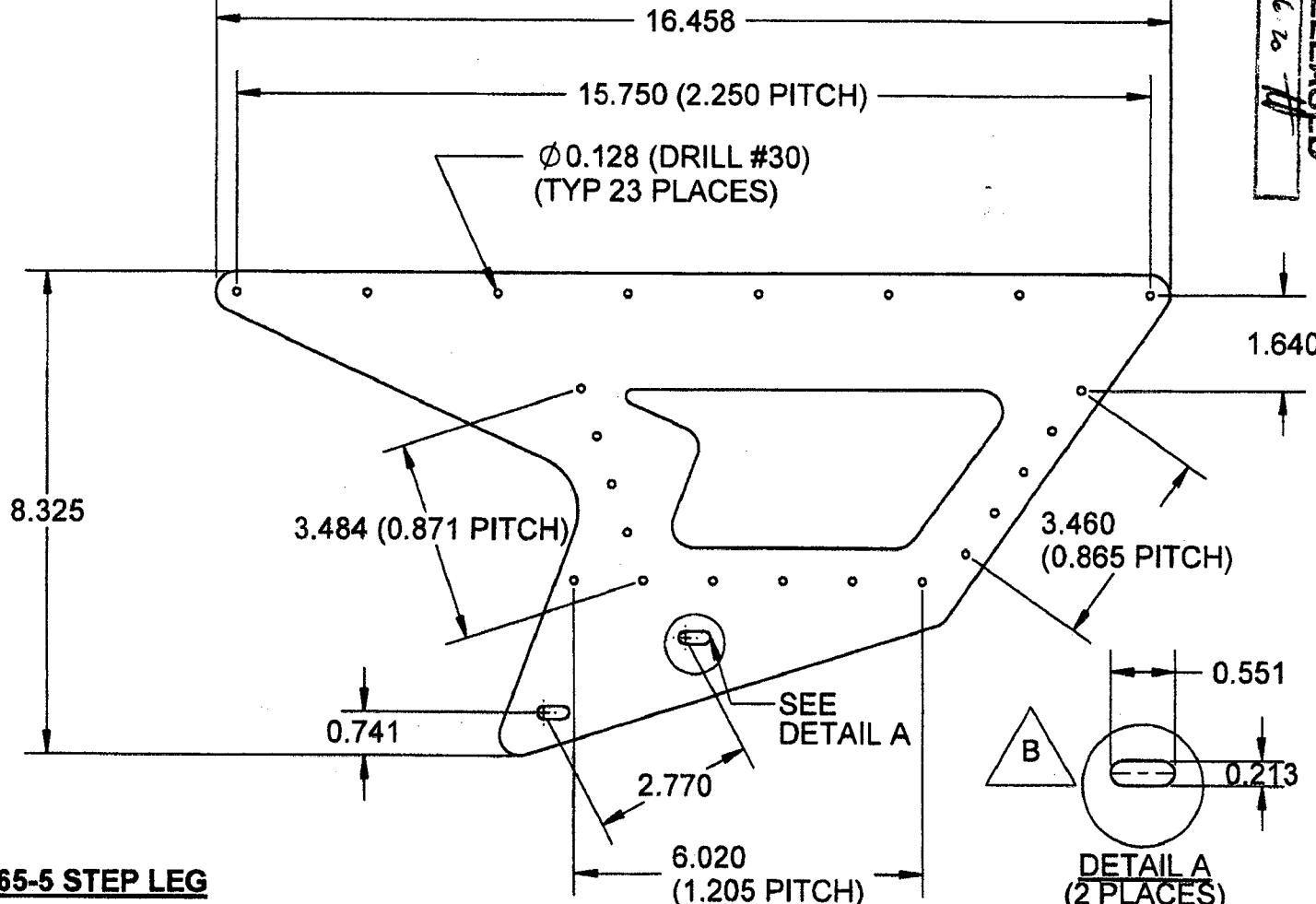
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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**DART**

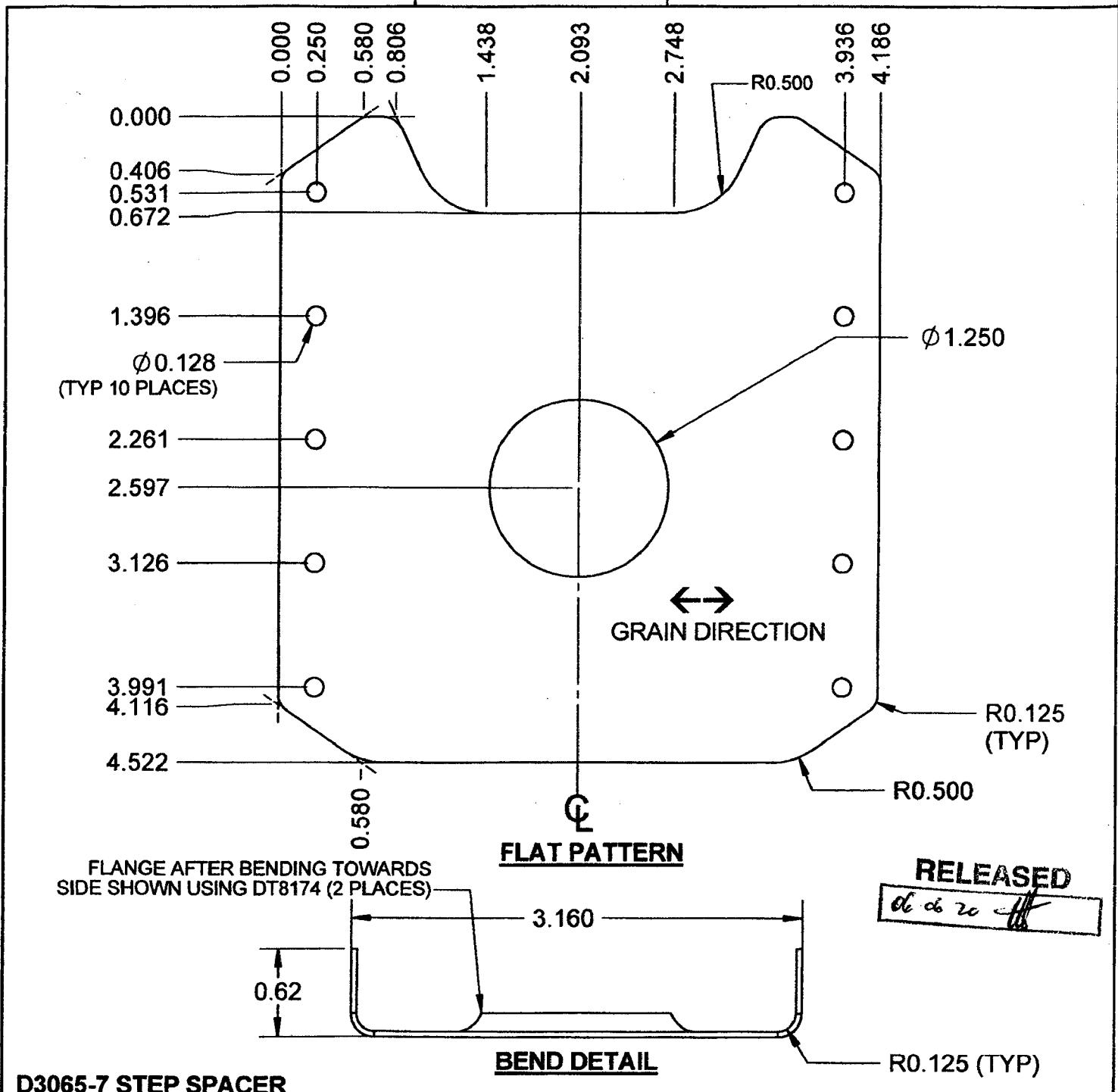
DESIGN <i>CP</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. <b>D3065</b>
DATE 06.05.23		TITLE <b>STEP LEG ASSEMBLY</b>

**RELEASED**  
06.06.20 *TH***D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>✓</i>	DRAWING NO. D3065	REV. B	SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1		

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	53819
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: B		Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by:	SAD	Audited by:	CP	Prototype Approval:	N/A
Date:	07/03/07	Date:	07/03/07	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	